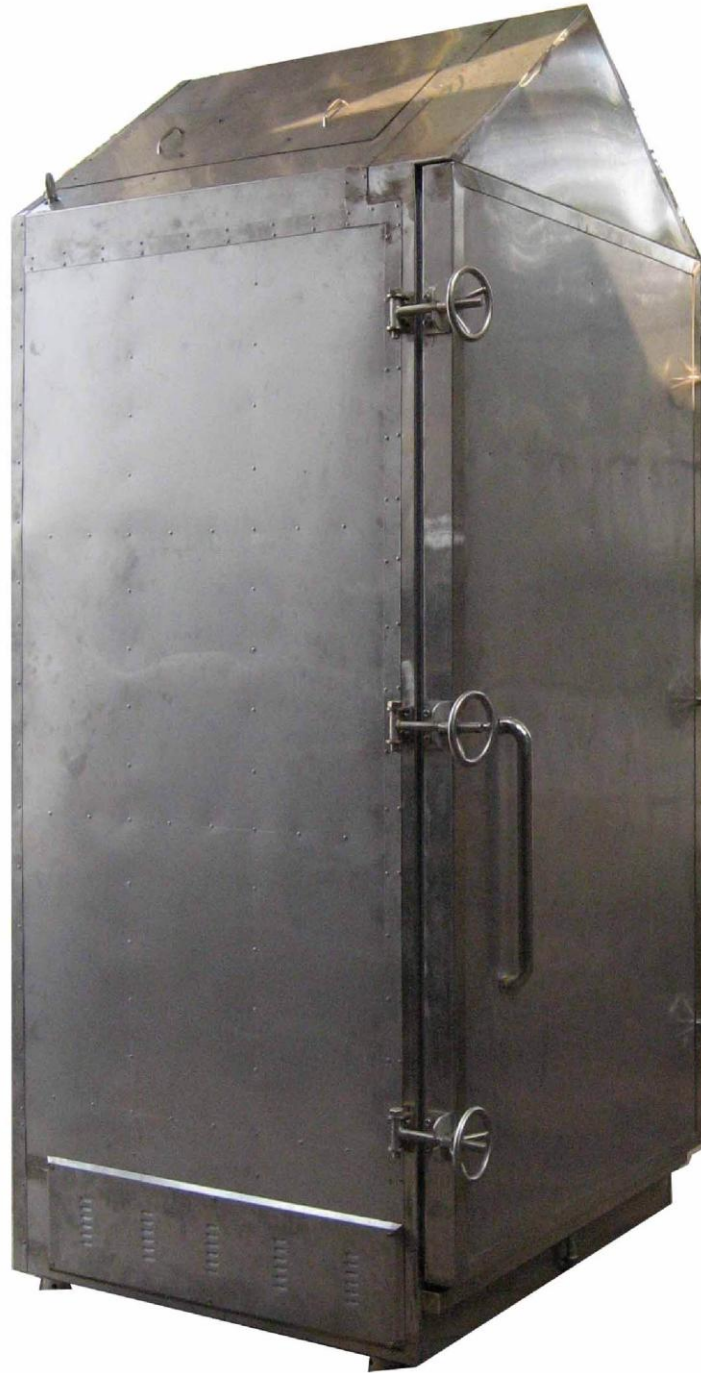


Atexco Electric heated Steam Box User's Manual

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Chapter1 Concerns of installation

1.1 Principles of steam

The principles of Steam Box are same as the Atmospheric Hanging Steam Box. Fabrics are hung on the special fabric frame while steaming. The temperature of steam chamber is about 102°C. And air vent is opened to atmosphere, exhausting continuously.

1.2 Introductions of assembly

Steam chamber

There is only a steam chamber with a sealing door on the front side. Dimension of the steam chamber is about 1.5m * 1.0m * 2.80m (Length*width*height).

Electric circuitry

Use three-phase five-wire system for power supply. The steam box must be connected to three-phase five-wire electric circuit which have 380V phase voltage, upwards 25A phase current and also have three-phase air switch, neutral wire and earth wire. The best is connecting the steam box to three-phase air switch directly but don't using three-phase power supply plug. Scathe will be taken to steam box if the value of breaking current isn't match the demarcating current value.

Water inflow

Connect water supply (The best is softened water) to water inlet by four-way water pipe.

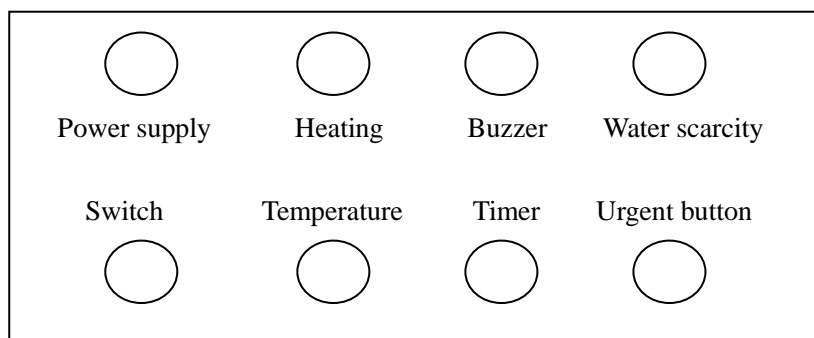
Drains

Use a water pipe (1 inch) connects to waterspout, then decontaminate the vented waste water. After that, vent waste water to the drain system.

Sealing Door

There are six rotary knobs on the sealing door. To avoid scalded, don't operate if the sealing door is opened.

Operation panel



Indicator light of power supply

It lights showing the control circuit working order.

Heating indicator light

It lights showing Electric heated steam box is been heating.

Buzzer

Buzzer call shows working completed.

Water scarcity warning light

It lights showing water scarcity. The following works will be halted, if not adding enough water to the steam box until light disposes.

Temperature director

Temperature can be set and shown by the temperature director. It is normal that there no increase of the temperature at the beginning of heating.

Controlling switch

Begin, end and restart steaming

Urgent button

It is a safety switch. Press it can stop heating urgently. After urgent button resetting, the aboriginal steaming state can be keep.

Timer

Set the time of steaming which counting from fabric started to been steamed to the setting temperature.

1.3 Accessories

Fabric vehicle and Fabric frame: There are two fabric frames and two fabric vehicles. Fabric frames for hanging fabrics. Fabric vehicles for pulling and pushing the fabric frames which hang fabrics on. Two wheels of fabric frame are put on to the track .The track is on the top of fabric vehicle. In this way, steam box can be pushed and pulled conveniently.

Chapter2 Major Technology Parameters

Max width of fabric	1.6m
Max width of steamed	34~136m
Working pressure of steam box	standard atmosphere
Highest steamed temperature	102℃
Rated dissipation power	12KW
Rated operational voltage	380/220VAC 50HZ three-phase five-wire

Chapter3 Instructions of installation

Connect to water inlet pipeline: connect to corresponding water inlet pipeline

Connect to drainage pipeline: connect to corresponding drainage pipeline

Chapter4 Instructions of adjustment

4.1 Temperature setting

Temperature parameter can be set by turning the knob which is on the operation panel. Normally, the set parameter is 101.5℃(real parameter is 102℃ at the beginning of timing)

4.2 Time setting

Users can adjust steaming time by adjusting the time controller within the main controller box. The detail methods as follow:

- (1) Lift the transparent shield of the adjustment.
- (2) Unit of time adjustment: Press “+” and “—”(“+” means “add”; “—” means “minus”) to make the unit of time is “M”(Minute)
- (3) Figure adjustment: Press “+” and “—”

Chapter5 Operation rules

5.1 Connect with power supply

Make control panel electrifying, at this moment, indicator light of power supply will light.

5.2 Fabric prepares:

Cotton fabric, wool fabric, ramie fabric, viscose fabric, knitted fabric and towel fabric

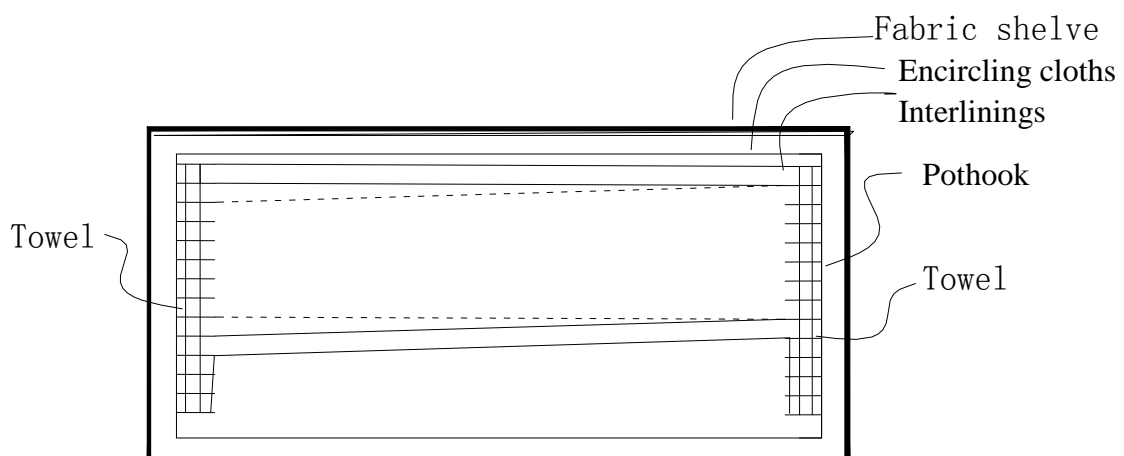
It was ringed with a circuit of double cotton canvas (good capillary effect, about 200 g/m² grams weighing) on the fabric shelves as encircling cloths. After hung with special interlinings, it is begun to hang the cloth on the first pothook of the shelves. The idiographic sketch map of method was shown as below.

Ordinary cotton printed fabrics can be hung up in turn by the method of S-shaped.

Heavy cotton fabrics, knitted fabric and rayon fabric with more moisture can be hung up in turn by the method of S-shaped hanging by a jump needle to increase the distances among the steaming fabrics for the purpose of absorbing moisture.

Because of less absorption of moisture, real silk and nylon fabric can be hung up by the method of S-shaped hanging two layer cloth per needle.

If the pothook can not been fully occupied by the steaming fabrics, it can be hung about two needles (about three meters long, and the width must be greater than the steaming fabric) of dried cotton canvas (If the pothooks of cloth shelves are fully hung off steaming fabrics, it is not necessary to be hung.) in the end and the front of the pothook. If the length of the steaming fabric is less than 1 m, it can be put the steaming fabric on the above canvas by pins and hung up the encircling cloths. Then, we can put special cotton covers on the top of the cloth shelves to prevent water dripping from the top of steaming box and balance the steaming humidity on the upside of the steaming fabrics.



5.3 Put fabric frame to steam box

Fabric frame is pulled into the steam box by the fabric vehicle which moves along with the track on the bottom of steam box. Close the sealing door, then turn the handle diagonally from the bottom up.

5.4 Startup steam box

Turn the control switch to “ON”, a new steaming procedure begin.

5.5 Open steam box

When steaming completed, users can take out the fabric frame by the step “5.3”.

It is necessary to close the sealing door to keep heating if want to keep on steaming. If not, just need cutting off power and water , and putting glove, fabric frame and fabric vehicle to specified position.

5.6 Reference list of steaming time

Fabric	Real temperature	steamed	Steamed time
Cotton fabric	102℃		13~15min
Silk fabric	102℃		35 min
Wool fabric	102℃		25~30min
Polyamide fabric	102℃		30min
knitted fabric	102℃		15min
Towel fabric and Heavy cotton fabric(more than 200g/m²)	102℃		25~30 min

- In principle, heavy fabric should be steamed more time.

5.7 Concerns of operation

1. To reduce color difference, steam box need warm-up before steaming.
2. Hang dossal fitly and avoid fabric pleating.
3. It is necessary to dry the ink before steaming to avoid color staining.
4. Filtrated soften water for working. Clean water tank with detergent every month if steam box be used often. If any malfunctions, please refer to user’s manual or contact with maintain service members.
5. Make sure main control switch closed before open the sealing door of steam box.
6. Please take note of cleanness.
7. Please take note of safety.

PS: Washing of fabric

Hand wash:

Cotton fabric (Rayon cotton fabric and ramie fabric wash in water refer to cotton

fabric):

Cold wash--Hot wash—whisking soap boiling (100*2~3min, soap powder: 2g/l) --rinse—drying or iron drying.

Silk fabric:

Cold wash three times--soap boiling with boiling water 2min--Cold wash--Wash fastness and softening(fastness 5g/l, softener 2g/l, dip5~6min in room temperature)—100℃ drying or iron drying.

Silk fabric hand wash should be soft, do not scrub, otherwise, the surface reflection ray of the fabric will be effected.

Machine wash:**Cotton fabric machine washable:**

Wash--dewatering--bleach wash--dewatering--soap boiling--dewatering--drying or ironing

Silk fabric and cotton fabric:

Cold wash--soap boiling with boiling water 2min--cold wash--fastness and softening--setting stenter dry --wrap-- finished product

Chapter6 Instructions of maintain

1. Steam box should be normal pressure vessel
2. The water at the bottom of steam box should be softening water.

Chapter7 Solutions of malfunction

status	reason	settle
Power Indicator light shows	1.Outer power supply switch isn't turn on 2.Three-phase circuit-breaker isn't switch on 3. Fuse burn out 4. Urgent button is pressed 5. Main control switch is turn off	1.turn on 2.switch on 3.replace 4.turn off 5.turn on
Water scarcity warning light shows	1. Water level low 2. Down-lead of water level sensor disconnect 3. Liquid Level Relay is spoiled	1.open water valve 2.reconnect 3.replace
No rise on temperature	1. At the beginning of heating, evaporation discharge too small. 2. Temperature Sensor is spoiled 3. Temperature director is spoiled 4. Electric heat element is spoiled	1.wait 2.replace 3.replace 4.replace
Timer don't time	1. Timer is spoiled 2. General Relay is spoiled 3. Temperature director is spoiled	1.replace 2.replace 3.replace

If malfunction can't be solved, users can contact with Engineering Department of our company.